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| Var | ·k () | rder | 11) | 62879 |
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Tuesday, October 12, 2010 1:05:05 PM



Page 1

Item ID:

D117-762-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

Start Qty: 1.00

Required Date: 10/22/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/

Operation Work Center ID

Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3582 Rev A

100

Document Control

DOCUMENT CONTROL

Memo

0.00

0.00

Photocopy bluefile & type labels per PPP D117-762-041

CHG001

120

CNC Bend 1

CNC Delta 100 Bender

0.00

BENDING MACHINE - SKIDTUBES

Memo

0.00

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending aid DT9632

2- cut fwd end of tube as per dwg

| Dart Ae | rospace | Ltd | | Mary Comments of | | e gradient | | • |
|---------|---------|---------------------|--------------|------------------------|----------------|--------------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANG | | 1 | | - |
| DATE | STEP | EP PROCEDURE CHANGE | | ANGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |
| Part No | • | PAR #: | Fault Cat | egory: | _ NCR: Yes N | No DQA: | _ Date: _ | |
| | | | Disposition: | | | | | |
| NCR: | | 1 | WORK ORI | DER NON-CONFORM | ANCE (NCR) |) | | · |
| DATE | | Description of NC | | Corrective Action Sect | ion B | Verification | Annessal | Ammuoval |
| DATE | STEP | Section A | | | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector |
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| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | Approval QC Inspector |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 2

Item ID:

D117-762-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

QC:

Start Qty: 1.00

Required Date: 10/22/2010

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Reference:

| Approvals: | |
|------------|--|
| | |

Process Plan:

Date:

Date:

Tooling:

Date:

Tool # Plan

Code

Date:

Stop

Sequence ID/ **Work Center ID**

130



Skidtubes

Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

1-Cut Aft end using DT8185

2-Deburr ends

Memo

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

Run

Accept

Qty

Start



Reject Reject Qty Number

Insp. Stamp

| W/O: | | | WORK ORDER (| HANGES | | • 4 | ·. | |
|---------|------|------------|------------------|------------|-------|-----|-------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No |): | PAR #: | Fault Category: | NCR: Yes | No DQ | A: | _ Date: _ | |
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| NCR: WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
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| | T | Description of NC | | Corrective Action Section B | | Verification | Ammana | Ammusical |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 3

Item ID:

D117-762-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

Start Qty: 1.00

Required Date: 10/22/2010

Req'd Qty: 1.00



Date:

Cust Item ID: Customer:

Tool ID

Reference:

| А | nn | rov | ผ | s: |
|---|----|-----|---|----|

Process Plan: ____

QC:

Operation

Description

Date:_____

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Date:

Run

Accept

Qty

Start Stop

Reject

Qty

Stop



Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

140

Skidtubes

Skidtubes

Skidtubes

0.00 Memo

1-Weld fwd cap D2964 per dwg D3582 and OSI 904 A/R AL ROD Batch: <u>M115778/m</u>111385

2-Grind flush

150

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

160

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

| Dait Aci | OSPACE | LU | | | | | | | | ٠, |
|------------|--------|-------------------|------------------------------|------------------------------|---------|----------------|--------------|---------|-------------------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANG | GES | | | | | |
| Part No: _ | STEP | PRO | OCEDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | Fault Cat | egory: | NCF | R: Yes I | No DQ | A: | Date: _ | |
| | R | esolution: | Disposition: QA: N/C Closed: | | | | | Date: _ | | |
| NCR: | | | WORK ORD | DER NON-CONFORM | ANCE | (NCR) | | | | |
| DATE | STEP | Description of NC | | | ction B | Oi 0 | Verific | cation | | Approval |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | on C | Chief Eng | QC Inspector |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 4

Item ID:

D117-762-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

Start Oty: 1.00

Required Date: 10/22/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

OC:

Process Plan:

Date:

Memo

Date:

Tooling:

SPC (Y/N):

Set Up/

Date: Date:

Tool # Plan

Code

Run

Start

Stop

Sequence ID/ **Work Center ID**

170

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Run Hours

0.00

0.00

. 181

180

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

10-10-19

| W/O: | | | W | ORK ORDER CHANGE | ES | | | |
|----------|------|-------------------|----------------------|------------------------------|--------------|---|-------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CH | ANGE | Ву | | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | Fault Ca | tegory: | NCR: Yes | No DQA:_ | Date: _ | |
| | R | esolution: | Disposit | ion: | QA: N/C C | losed: | Date: _ | |
| NCR: | | V | VORK OR | DER NON-CONFORMA | NCE (NC | R) . | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verificati | on Approval | Approval |
| Part No: | SIEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | & Section C | | QC Inspector |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 5

Item ID:

D117-762-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

Start Oty: 1.00

Required Date: 10/22/2010

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Sequence ID/

Work Center ID

190

Skidtubes Skidtubes

Operation Description

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Stop

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sike Flex Batch: MIS/14 Exp Date: // 15/

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B. A/R AL ROD Batch:

6-Grind welds flush

BE 10/10/21

200

QC10- Inspect visual per QSI004- ground welds

0.00

Quality Control

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
|---------|------|--------------------|----------------------|------------------------------|--------------|--------|--------|-------------------------------------|--------------------------|--|--|--|
| DATE | STEP | PRO | CEDURE CH | ANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC_Inspector | | | |
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| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: Yes | No DQ | A: | Date: | | | | |
| | | esolution: | | | | | | Date: | | | | |
| NCR: | | . V | VORK ORI | DER NON-CONFORM | ANCE (NCI | 7) | | | | | | |
| DATE | STEP | Description of NC | | | tion B | Verifi | cation | Approval | Approval | | | |
| DATE | | Section A | Initial Chief Eng | Action Description Chief Eng | Sign of Date | | tion C | Chief Eng | QC Inspector | | | |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 6

Item ID:

D117-762-041

Accept



Setup Start

Stop



Revision ID:

Replacement Skidtube Item Name:

Start Date: 10/12/2010

Start Qty: 1.00

Req'd Qty: 1.00 **Required Date:** 10/22/2010



Date:

Cust Item ID: Customer:

Reference:

| Approvals: |
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|------------|

Process Plan: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

210

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code Reject **Qty**

Accept

Qty

Reject Number

Insp. Stamp

215



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Memo

0.00

0.00

PTO =)

220



Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

m 115091

0.00 /10-10-25.

0.00

| W/O: | | WORK ORDER CHANGE | S | | | <u>-</u> | |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC,Inspector |
| 10/10/22 | 215 | Realodine Touch-up Asper PAR 09-043 permanuant change! |)U | 10/10/22 | XI) | | (6/10/2) |
| | | | | | - | | |

| Part No: | | PAR #: | Fault Category: | NCR: Yes No | DQA: | Date: | |
|----------|-------------|--------|-----------------|----------------|----------|-------|--|
| | Resolution: | | Disposition: | QA: N/C Closed | : | Date: | |

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|----------------------------------|-------------------|----------------------|------------------------------|----------------|-----------|-----------------------|--------------|--|
| | | Description of NC | | Corrective Action Section B | Verification | Approval | Approval | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | QC Inspector | |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 7

Item ID:

D117-762-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 10/22/2010

Replacement Skidtube

Start Date:

10/12/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

0.00

0.00

Date: Date:

Tool ID

Run

Start

Reject

Stop

Sequence ID/ **Work Center ID**

230

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

10/10/26

Code

Tool # Plan

Qty

Accept

Qty

Reject

Insp. Number Stamp

240

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

10/10/76

Install Wearplate & Ground Wire inserts as per Dwg D3582.

| W/O: | | | W | ORK ORDER CHANG | SES | | | |
|---------|---------------------------------------|----------------------|------------------------------|-----------------|--------------|-----------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date Qty | Approval Chief Eng./ Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cat | egory: | _ NCR: Yes N | No DQA : | Date: _ | · |
| | R | esolution: | Disposition | on: | QA: N/C Clo | sed: | Date: _ | |
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| DATE | CTED | Description of NC | | tion B | Verification | Approval | Approval | |
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| Work | Order | ID | 62879 |
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Tuesday, October 12, 2010 1:05:05 PM



Page 8

| Item ID: Revision ID: | D117-762-04 | | | Accept | | | | | Setup S | Start Stop | | |
|---|---|---|--|-----------------------|-------------|-------|--------------|---------------|--------------|---------------|------------------|----------------|
| | Replacement S 10/12/2010 10/22/2010 | Start Qty: 1.00 Req'd Qty: 1.00 | | | Cust Item : | | | | 5 | y | | |
| Approvals: | | n: | Date: | Tooling: SPC (Y/N): | | ate: | |] | | Start Stop | | |
| Sequence ID/ Work Center II 250 HandFinish Hand Finishing | | A/R 241 3-Install We Note:Instal section I **** A/R 241 4-assemble A/R 55-o'ri | cap as per Dwg D3582, Sika Flex Batch: I A Exp Date: I | and apply o'ring lube | | Tool# | Plan Code | Accept Qty | Rejec Qty | | Reject Number | Insp. Stamp |
| 260 QC Quality Control | | QC5- Inspect part comp Memo | leteness to step on W/O | 0.00 | 07 | | | (FO | | | | |

| W/O: | | | V | ORK ORDER CHANGE | ES | | | | |
|----------|------|-------------------|----------------------|------------------------------|----------------|-----------------|------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CH | IANGE | Ву | Date | Qty | Approval Chief Eng'/ Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Ca | tegory: | NCR: Yes | No DQA : | | _ Date: _ | |
| | R | esolution: | Disposit | ion: | QA: N/C Cld | sed: | | Date: _ | |
| NCR: | | V | VORK OR | DER NON-CONFORMA | NCE (NCR |) | | | - |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verifica | tion | Approval | Approval |
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Work Order ID 62879

Tuesday, October 12, 2010 1:05:05 PM



Page 9

Item ID:

D117-762-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/12/2010

Start Qty: 1.00

Reg'd Oty: 1.00 **Required Date: 10/22/2010**



Cust Item ID: Customer:

Reference:

| Approvals: | |
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QC:

Process Plan:

Date:

0.00

0.00

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Date:

Start

Stop



Sequence ID/ **Work Center ID**

270

Packaging

Packaging

Packaging

Operation

Description

Identify and pack for shipping as per PPP D117-762-041

Date:

280

Quality Control

Memo

Location:

PPP Rev:

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Run

Tool # Plan Accept

Code

Oty

Reject **Oty**

Reject Insp. Number

Stamp

| W/O: | | | WC | RK ORDER CHAN | IGES | | | | | |
|---------|------|-------------------|----------------------|---------------------------------------|-------|----------------|--------------|------------|-------------------------------|-----------------------|
| DATE | STEP | PRO | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR | : Yes I | No DQ | A : | Date: | |
| | Re | solution: | Disposition | n: | QA: | N/C Clo | sed: | | Date: | |
| NCR: | | | WORK ORDI | ER NON-CONFORM | MANCE | (NCR) |) | | | • |
| DATE | STEP | Description of NC | | Corrective Action Section B | | | Verific | | | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | 1 | Sign & Date | Secti | on C | Chief Eng | QC Inspector |
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Picklist Print

Tuesday, October 12, 2010 1:05:09:PM

Work Order ID: 62879

Parent Item:

D117-762-041

Parent Item Name:

Replacement Skidtube



Start Date: 10/12/2010

Required Date: 10/22/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A□07.06.11□New Issue□ EC

IPP Rev.B 08-02-22 change to revA as per dwg DD verified by EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-------------------------------------|------------------------|---------------|-------------|-----------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|-----------------|----------------|--------|
| D2962-150 3.540 Outer Tube, Extrut | 88 800 BB | Manufactured | No | | | | Each | 100.0000 | 1 | 1 | | | |
| 5.540 Outer Fuoc, Extua | | | | Location HALL | 28672 | <u>Loc (</u> | Otv 100 27 | Loc Code | G | D | D | 0 | -10 |
| D2964 | | Manufactured | No | . ' | | 140 | 73 Each | 19.0000 | ı | 1 | _ | | |
| | | | | <u>Location</u> LG | | Loc | Qty 19 | Loc Code | _ | | | _ | |
| D2971 | | Manufactured | No | | 14101 | 190 | 19 Each | 27.0000 | 1 | 1 | _ <i>&E</i> | 10-10 | シーノタ |
| | | | | Location | | Loc | _ | Loc Code | | | | | |
| | | | | LG | 44445 | | 27 27 | | _ _ | | - - L | 3E 19 | 1421 |
| D3584-1 | | Manufactured | No | - | B 6288 | 190 | Each | 0.0000 | 1 | 1 / | | B | 10/0/2 |

| W/O: | | | W | ORK ORDER CHANG | GES | | | | | |
|-----------------|------|-------------------|-------------------------------------|------------------------------|--------|----------------|---------------|-------|-------------------------------|-----------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QÇ Inspector |
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| Part No | • | PAR #: | Fault Cate | egory: | _ NCR: | Yes N | lo DQA | : | _ Date: _ | |
| | | esolution: | | | | | | | | |
| NCR: | | \ | WORK ORE | ER NON-CONFORM | ANCE | (NCR) | | | | |
| | | Description of NC | Description of NC Corrective Action | | | | Verifica | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Sectio | | Chief Eng | QC Inspector |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879 Parent Item: D117-762-041 ા, Parent Item Name: Replacement Skidtube Required Date: 10/22/2010 Start Date: 10/12/2010 Required Qty: 1.00 Start Qty: 1.00 D2973 Manufactured No 190 162,0000 2 Each Cross Bolt Spacer Location Loc Qty Loc Code LG 162 BF 10/10/21 14636 162 D3662-3 Manufactured No 190 Each 27.0000 Crossbolt Spacer Location Loc Qty Loc Code LG 27 44456 27 D3662-1 Manufactured No 190 19.0000 Each Crossbolt Spacer Location Loc Qty Loc Code LG _ BE 10/10/2/ 19 55328 19 ALS4-1032-130 Purchased No 240 Each 1,047.000 36 Insert Location Loc Qty Loc Code PKG11 998 114723 998 X36 ST282 M115911 10 110511 10 ST381 39 114654 39

| W/O: | | | W | ORK ORDER CHAN | GES | <u> </u> | | |
|---------|------|-------------------|------------------------------------|------------------------------|----------------|--------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date Qty | Approval Chief Eng*/ Prod Mgr | Approval QC inspector |
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| Part No | : | PAR #: | Fault Cate | egory: | NCR: Yes N | lo DQA: | Date: _ | |
| | R | esolution: | Disposition | on: | QA: N/C Clo | sed: | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORM | IANCE (NCR) | | | |
| DATE | STEP | Description of NC | escription of NC Corrective Action | | | Verification | | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879 Parent Item: D117-762-041 Parent Item Name: Replacement Skidtube **Required Date: 10/22/2010** Start Date: 10/12/2010 Start Qty: 1.00 Required Qty: 1.00 ALS4-428-165 Purchased No 240 107.0000 Each Inserts Location Loc Qty Loc Code FP 7 6989 7 ST282 100 114172 100 D2965 Manufactured No 250 Each 42.0000 Cap, 105 Skidtube Location Loc Qty Loc Code FP4 42 52057 42 D3508-3 Manufactured No 250 Each 2.0000 Wearplate Location Loc Qty Loc Code FP 38527 1 FP21 55339 D3508-9 Manufactured 250 4.0000 Each Wearplate Location Loc Qty Loc Code FP21 54580

| W/O: | | | W | ORK ORDER CHANG | GES | | | |
|---------|------|-------------------|----------------------|------------------------------|----------------|-----------------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CH | ANGE | Ву | Date Qty | Approval Chief Eng'/ Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | Fault Cat | egory: | NCR: Yes | No DQA : | Date: _ | |
| | | esolution: | | | | | | |
| NCR: | | | WORK ORE | DER NON-CONFORM | IANCE (NCR |) | | |
| DATE | STEP | Description of NC | ction B | Verification | Approvai | Approval | | |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | QC Inspector |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879 Parent Item: D117-762-041 Parent Item Name: Replacement Skidtube Start Date: 10/12/2010 **Required Date: 10/22/2010** Start Qty: 1.00 Required Qty: 1.00 D3558-3 Manufactured No 250 Each 13.0000 Gasket Loc Qty Location Loc Code FP 13 42253 1 12 55468_ D3558-9 250 Each 18.0000 Manufactured No Gasket Location Loc Qty Loc Code FP 18 50928 4 55469 14 D3558-11 Manufactured No 250 Each 3.0000 Gasket Location Loc Qty Loc Code FP 3 42254 3 D3558-13 Manufactured No 250 Each 35.0000 Gasket Location Loc Qty Loc Code FP 35 55467 59558 34

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
|----------|------|--------------------|---------------------------------------|------------------------------|---------|--------------|---------|-----|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROC | CEDURE CH | IANGE | Ву | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No: | | PAR #: | Fault Category: I | | | es No | DQA | | Date: | | | |
| | R | esolution: | _ Disposit | ion: | QA: N/C | Clos | ed: | | Date: | | | |
| NCR: | | | ORK OR | DER NON-CONFORMA | NCE (N | CR) | | | | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | verification | | | Approval | Approval | | |
| | OIL. | Section A | Initial Chief Eng | Action Description Chief Eng | | n & ate | Section | 1 C | Chief Eng | QC Inspector | | |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879 Parent Item: D117-762-041 Parent Item Name: Replacement Skidtube Start Date: 10/12/2010 **Required Date: 10/22/2010** Start Qty: 1.00 Required Oty: 1.00 D3508-11 Manufactured 250 12.0000 Each Al 10/10/26 Wearplate Location Loc Qty Loc Code FP16 12 12 54644 D3508-13 Manufactured 250 Each 3.0000 10/10/26 Wearplate Location Loc Qty Loc Code FP 3 3 54645 D3492-051 Manufactured 250 Each 54.0000 10/10/26 Plug Assembly Location Loc Qty Loc Code FP013 54 44633 4 55622 50 D3492-049 Manufactured No 250 Each 29.0000 Plug Assembly Location Loc Qty Loc Code FP011 29 55621 29 D3492-053 Manufactured No 250 Each 19.0000 Plug Assembly Location Loc Oty Loc Code FP 19 X b 19 54641

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| W/O: | | | WO | RK ORDER CHANG | ES | | ···· | | |
| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC inspector |
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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DC | A: | _ Date: _ | |
| | Res | solution: | Disposition | n: | _ QA: N/C | Closed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NC | R) | | | |
| | | Description of NC | | | on B | Verifi | cation | Approval | Approval |
| Part No: _ | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Dat | ∖& Sec | tion C | Chief Eng | QC Inspector |
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Tuesday, October 12, 2010 1:05:09 PM

| Work Order ID: 62879 | | | | | | |
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| Parent Item: D117-762-041 | | | | | | |
| Parent Item Name: Replacement Skidtu | be | | | | Start Date: | • |
| | | | | | Start Qty: | 1.00 Required Qty: 1.00 |
| AN960JD10L N <u>AS1149D0332</u> J | Purchased | No | | 250 Each | 0.0000 2 | 2 |
| Washer | | | | 111113218 | | 25/01/01/26 |
| AN3C4A | Purchased | No | | 250 Each | 1,511.000 28 | 28 |
| BOLT | | | | | | Il 10/10/26 |
| | | <u>Loca</u> | <u>tion</u> | Loc Oty | Loc Code | |
| | | ST24 | 5 | 20 | | |
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| | | | 115589 | 1000 | | |
| AN3C5A | Purchased | No | | 250 Each | 1,169.000 2 | 2 |
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| | | Loca | <u>tion</u> | Loc Qty | Loc Code | |
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| N/O: | | | WORK ORDER CHANGES | | | | | | | | | | |
| DATE | STEP | PROG | CEDURE CH | ANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No | : | PAR #: | Fault Ca | tegory: | NCF | R: Yes | No DQ | A: | _ Date: _ | | | | |
| | R | esolution: | _ Disposit | ion: | QA: | N/C Clo | sed: | | Date: | | | | |
| NCR: | | W | ORK ORI | DER NON-CONFORM | MANCE | (NCR) |) | | | | | | |
| DATE | STEP | Description of NC | | | ection B | O: 9 | Verific | ation | Approval | Approval | | | |
| DAIL | 3121 | Section A | Initial Chief Eng | Action Description Chief Eng | n | Sign & Date | Secti | on C | Chief Eng | QC Inspector | | | |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879 Parent Item: D117-762-041 Parent Item Name: Replacement Skidtube Start Date: 10/12/2010 **Required Date: 10/22/2010** Start Qty: 1.00 Required Qty: 1.00 AN960JD416L NAS1149D0416J Purchased No 250 Each 223.0000 2 10/10/26 Washer Location Loc Qty Loc Code ST346 223 106785 2 110153 221 AN960C10L NAS1149C0332 Each 250 Purchased No 29.0000 28 28 25/10/10/26 M115832 washer Location Loc Qty Loc Code ST245 29 107534 29 AN4-4A Purchased No 250 Each 186.0000 10/10/26 Bolt Location Loc Qty Loc Code ST356 183 114615 183 ST361 3 108138 2 111295 NAS1611-012 Purchased No 250 Each 110.0000 10/10/26 O-RING Location Loc Qty Loc Code FP 110 108673 113845 101

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| W/O: | | | WO | RK ORDER CHANGE | S | | | | |
| DATE | STEP | PAR #: Fault Category: NCR: Yes No DQA: Date: Solution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) Description of NC Corrective Action Section B | Approval QQ Inspector | | | | | | |
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| Part No | : | PAR #: | Fault Categ | ory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| Resolution: | | Disposition | : | QA: N/C CI | osed: | | Date: _ | | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NCF | R) | | | |
| DATE | CTED | Description of NC | | | | Verific | cation | Approval | Approval |
| | STEP | | | | |) [| | | QC Inspector |
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Tuesday, October 12, 2010 1:05:09 PM

Work Order ID: 62879

Parent Item:

D117-762-041

Parent Item Name: Replacement Skidtube



Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

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O-RING

Purchased

Each

25.0000

NAS1611-016 Purchased

No

No

| Location | Lo | c Oty |
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| FP | | 25 |
| 107178 | | 5 |
| 115101 | | 20 |
| | 250 | Each |

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10/10/26

| Location | Loc Oty | Loc Code | |
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| FP , | 109 | | |
| 107178 | 9 | | |
| 112492 | 50 | | _ x 2 |
| 113524 | 50 | | |

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| W/O: | | | WC | RK ORDER CHANG | ES | | | | |
| DATE | STEP | PRO | DCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | \: | _ Date: _ | |
| | | esolution: | | | | | | | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NCF | R) | · · | | |
| | | Description of NC | | Corrective Action Section | Section B Verification | | | | Approval |
| DATE | STEP | Section A | Initial Chief Eng | | | Section | | Approval Chief Eng | QC Inspector |
| | | The same of the sa | | | | | | | |
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PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

| Qty | Part Number | Description |
|-----|---------------|-------------------|
| X | D3582-041 | SKIDTUBE ASSEMBLY |
| | | |
| 1 | D2962-150 | EXTRUSION |
| 1 | D2964 | CAP |
| 1. | D2965 | CAP |
| 1 | D2971 | CROSS BOLT SPACER |
| 2 | D2973 | CROSS BOLT SPACER |
| 2 | D3492-049 | PLUG ASSEMBLY |
| 2 | D3492-051 | PLUG ASSEMBLY |
| 6 | D3492-053 | PLUG ASSEMBLY |
| 1 | D3508-3 | WEARPLATE |
| 1 | D3508-9 | WEARPLATE |
| . 1 | D3508-11 | WEARPLATE |
| 1 | D3508-13 | WEARPLATE |
| 1 | D3558-3 | GASKET |
| 1 | D3558-9 | GASKET |
| 1 | D3558-11 | GASKET |
| 1 | D3558-13 | GASKET |
| | D3584-1 | WEB |
| 3 | D3662-1 | CROSS BOLT SPACER |
| 1 | D3662-3 | CROSS BOLT SPACER |
| | | tt. |
| 36 | AELS-1032-130 | INSERT |
| 2 | ALS7-428-165 | INSERT |
| 28 | AN3C4A | BOLT |
| 2 | AN3-5A | BOLT |
| 2 | AN4-4A | BOLT |
| 28 | AN960C10L .*. | WASHER |
| 2 | AN960JD10L | WASHER |
| 2 | AN960JD416L · | WASHER |

GENERAL NOTES:

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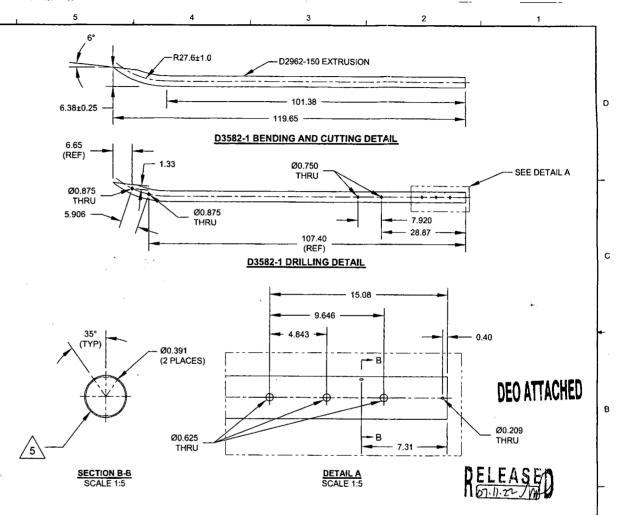
- 1) ALL DIMENSIONS ARE IN INCHES
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) WELDING TO BE DONE PER DART QSI 004.
 4) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- DART Q3I 019 AF IER BENDING.

 S USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.

 DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
- LOCATIONS.

В

- 7) FINISH:
 - A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
 - B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 C) ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI



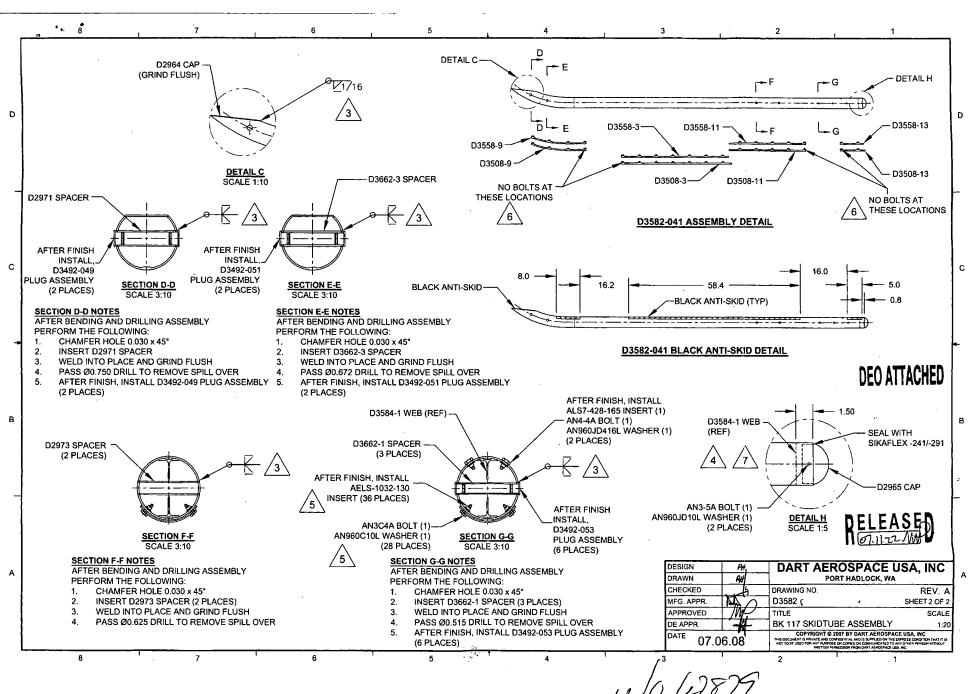
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|---------|--------|------|---|-----------------------------|
| REV. | | | DESCRIPTION BY | DATE |
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| DRAWN | | PH | PORT HADLOCK, WA | |
| CHECK | ED | | DRAWING NO. | REV. A |
| MFG. AF | PPR. | N O | D3582 | SHEET 1 OF 2 |
| APPRO' | VED | M | TITLE | SCALE |
| DE APP | R. | di | BK 117 SKIDTUBE ASSEMBLY | 1:20 |
| DATE | 07.00 | 6.08 | COPYRIGHT © 2007 BY DART AEROSPAC THIS OCCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE E NOT TO BE USED FOR ANY PURPOSE OR COMPANIED AND IS | XPRESS CONDITION THAT IT IS |

NO_U2879-P) 10-10-12

| Dart Ae | rospace Lta | | | | | | | • |
|---------|-------------|--------|--------------------|---------------|---------|------------|--------------------------------|--------------------------|
| W/O: | | | WORK ORDER | CHANGES | | | | |
| DATE | STEP | PR | OCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng /, Prod Mgr | Approval QC Inspector |
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| Part No |) <u>.</u> | PAR #: | Fault Category: | NCR: Ye | s No DQ | A : | Date: | <u>l</u> |
| | | | Disposition: | | | | | |
| NCD. | | | WORK ORDER NON-CON | IFORMANCE (NO | (R) | | | |

| | , | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|-------------------|----------------------------------|--|--|--|--|--|--|--|
| | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval QC inspector | | |
| STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Chief Eng | | | |
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| | STEP | STEP Description of NC Section A | STEP Description of NC Section A Initial Chief Eng | STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Initial Chief Eng Chief Eng | STEP Description of NC Section A Chief Eng Chi | STEP Description of NC Section A Chief Eng Chi | STEP Description of NC Section A Description Section B Sign & Date Chief Eng | | |



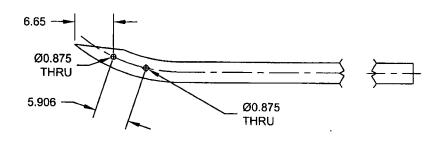
| Dart | Aero | space | Ltd |
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| W/O: | | · | WC | RK ORDER CHANG | SES | | | · · · · · · · · · · · · · · · · · · · | | | |
| DATE | STEP | PROCEDURE CHANGE | | | | Ву | Date | Qty | Approval Chief Eng*/ Prod Mgr | Approval QG Inspector | |
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| Part No |): | PAR #: | Fault Category: NC | | _ NCR: | ICR: Yes No DQA: Date: | | | | | |
| Resolution: | | esolution: | Disposition: | | QA: N | QA: N/C Closed: Date: | | | | | |
| NCR: | | • | WORK ORDI | R NON-CONFORM | ANCE (| (NCR) | | | | | |
| | | Description of NC | Corrective Action | | tion B | | | Verification | Approval Chief Eng | Approval QC Inspector | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | n Sign Date | | Section C | | | | |
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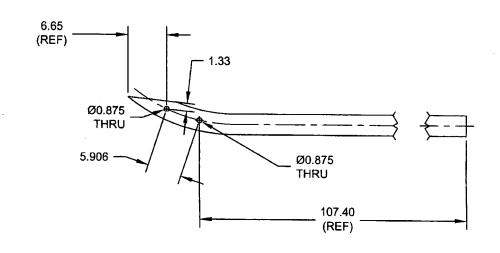
| DRAWING N | IO. TITLE | , REV. A | DART AEROSPACE US | A, INC D.E.O. NO. | SHEET NO. | SCALE |
|-----------|------------|----------------|-------------------|---------------------|---------------|-------|
| D3582 | BK 117 SKI | DTUBE ASSEMBLY | ENGINEERING ORD | ER D3582-A-1 | SHEET 1 OF 1 | NTS |
| DRAWN | PU | CHECKED | MFG. APPR. | APPROVED (AN) | DE APPR. | |
| DATE | 09.04.06 | DATE 64.04.06 | DATE 09.04.06 | DATE MICHOL | DATE 09.04-00 | 6 |

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR: UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



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WRITTEN PERMISSION PROM DART AEROSPACE USA, INC.

| W/O: | | | W | ORK ORDER CHAN | GES | | | | | | | |
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| DATE STEP | | PRO | PROCEDURE CHANGE | | | у | Date | Qty | Approval Chief Eng Prod Mgr | Approval • QC Inspector | | |
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| DATE | STEP | Description of NC | Corrective Action Section B | | | | Verification | | Approval | Approval | | |
| DAIL | | Section A | Initial Chief Eng | Action Description Chief Eng | | ign & Date | Section C | on C | Chief Eng | QC Inspector | | |
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